

Fig. 1

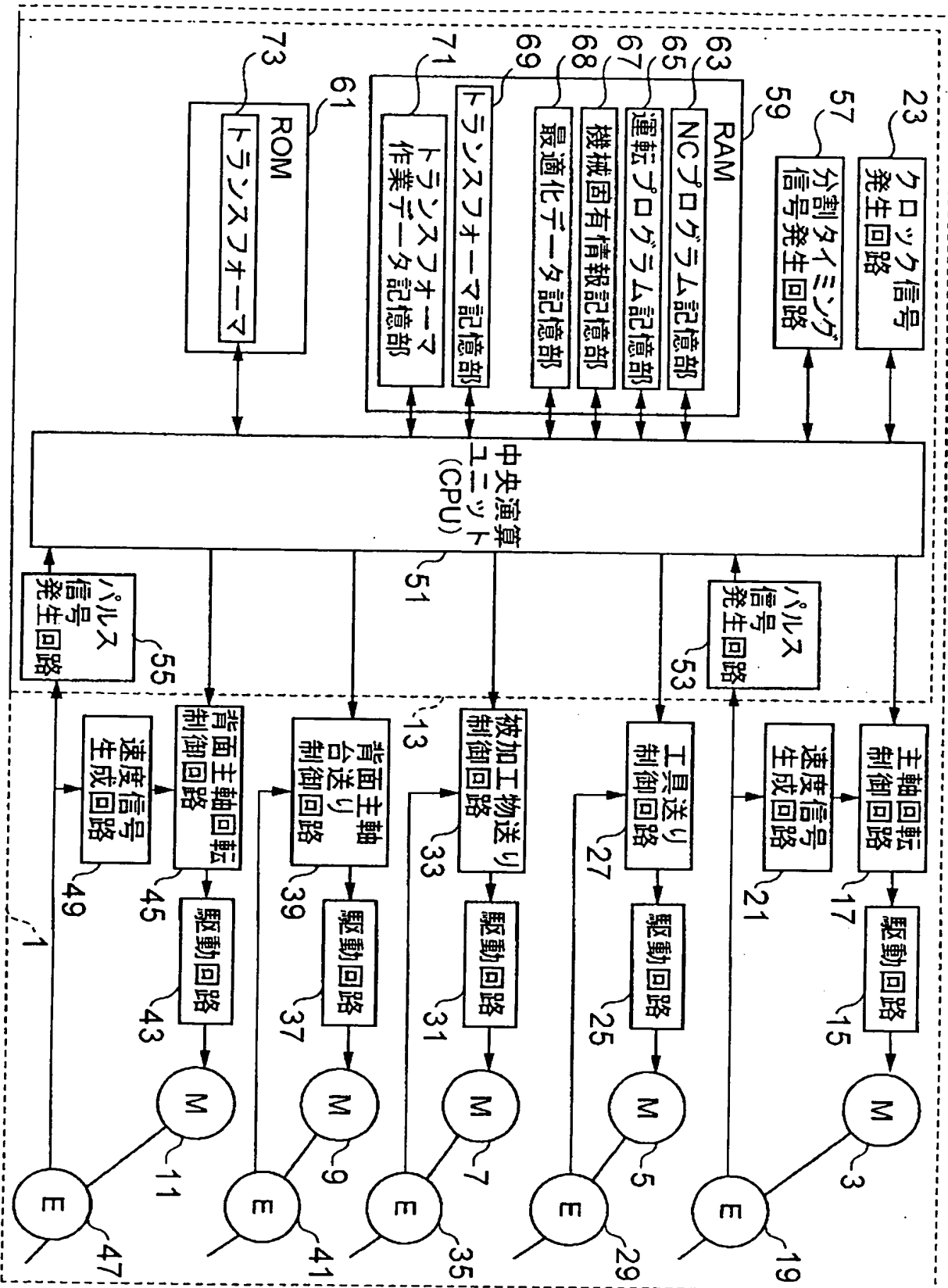


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Fig-2

(図2)

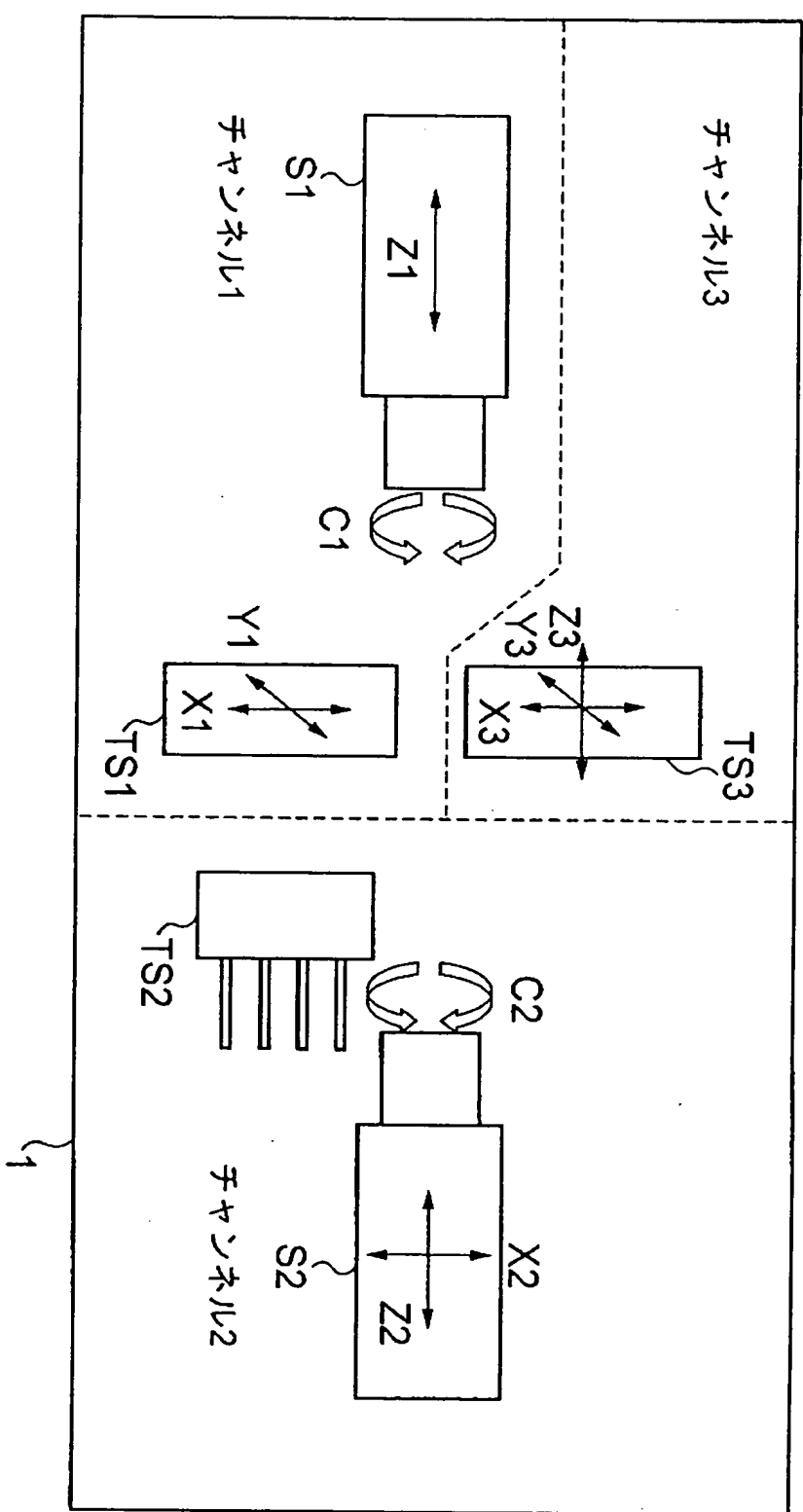
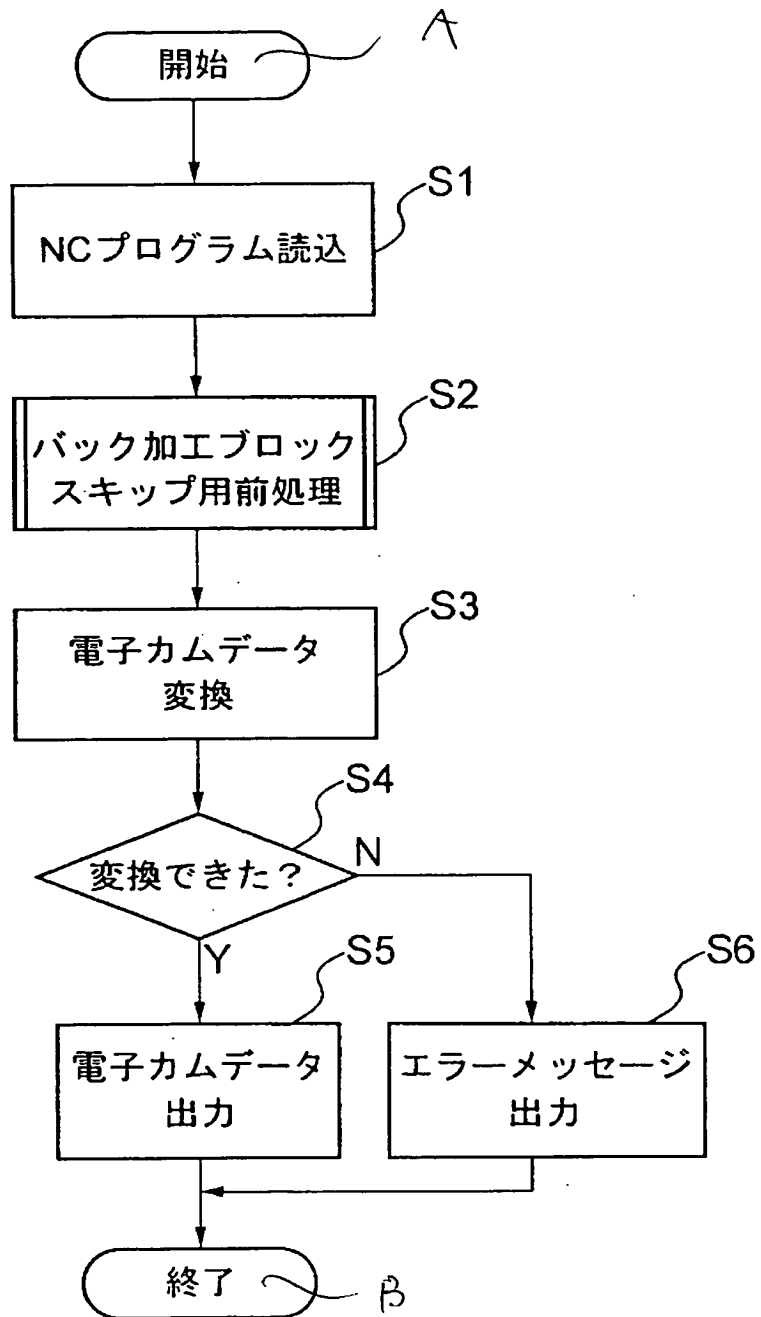


Fig-3

[図3]



[E4]

Fig. 4

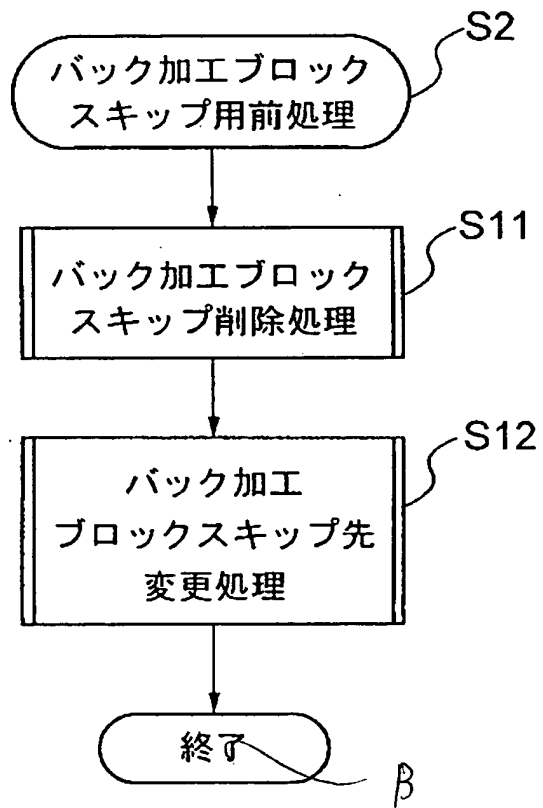


Fig. 5

[15]

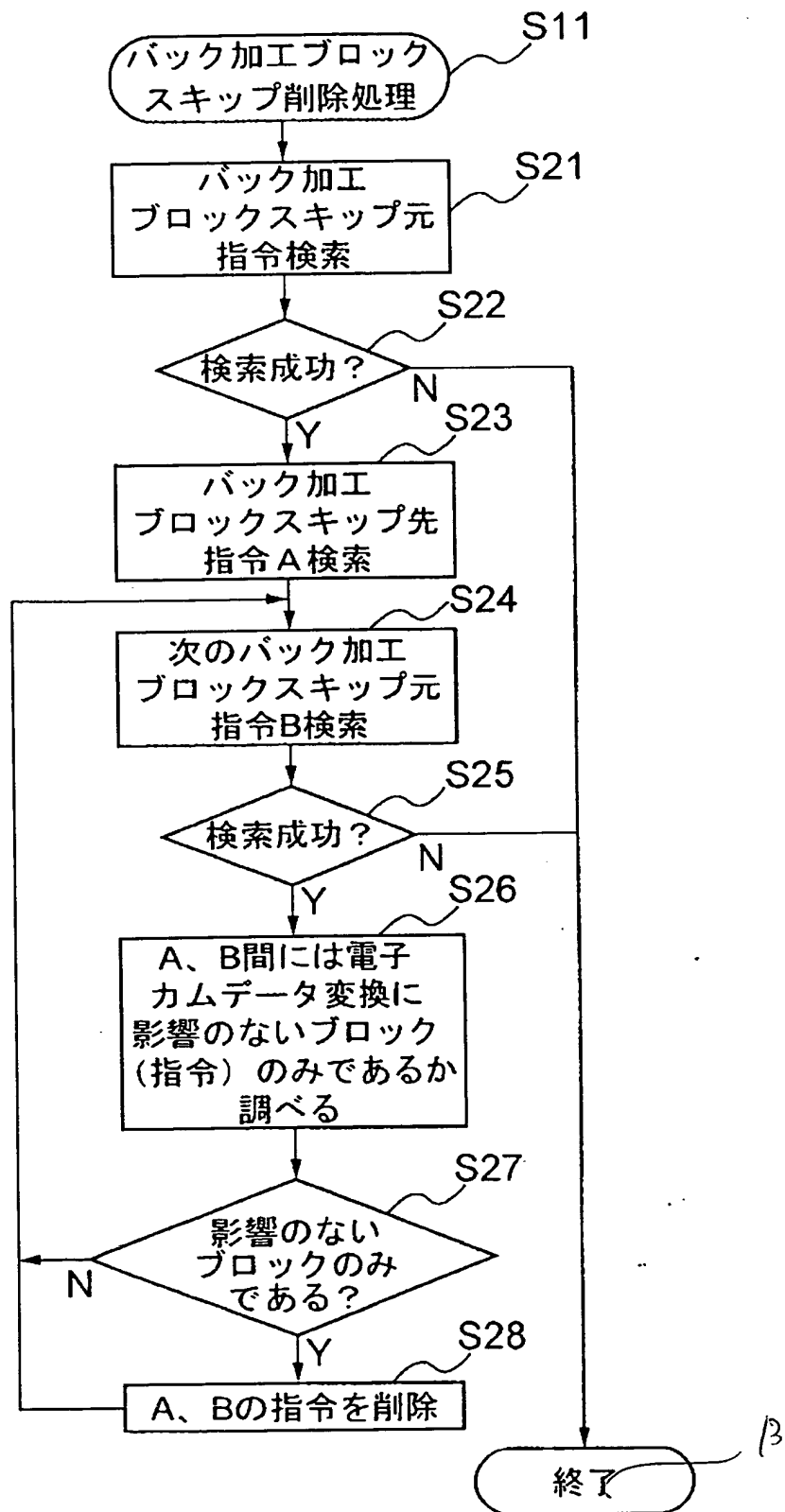


Fig-6

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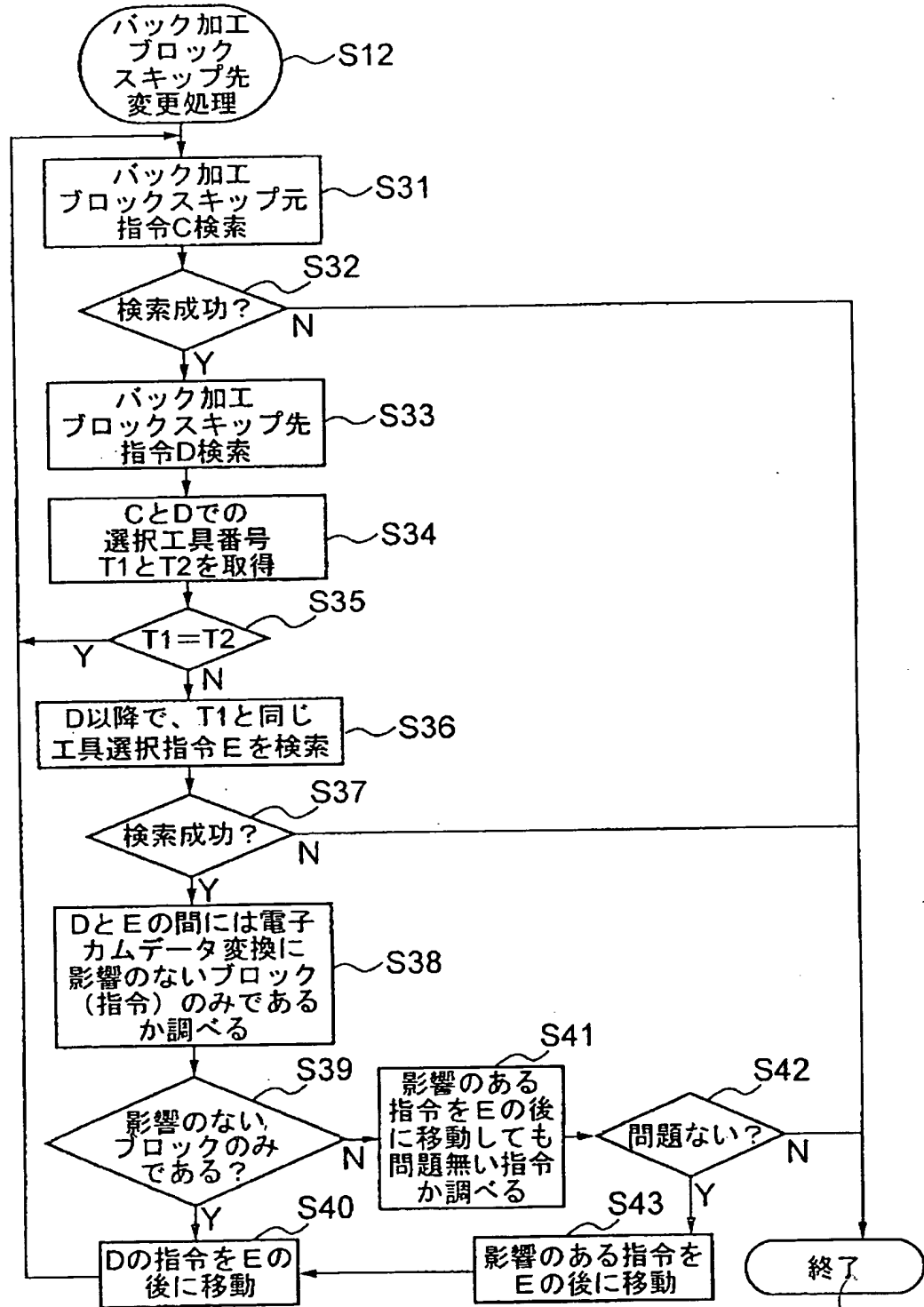


Fig-7

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CH1  
TOP:  
G0Z0.0

waitm (1,1,2,3)  
M20  
G0X10.0Z10.0  
G28X60.0

CH3  
TOP:

waitm (1,1,2,3)  
M20  
G28Z0.0

CH2  
TOP:  
G95  
T2000  
waitm (1,1,2,3)  
M20  
M75

N1  
;msg ("DRILL")  
T3800  
wcs132  
MS2  
M3,S2000

waitm (2,2,3)  
G28X60.0

EM75:  
waitm (2,2,3)  
M75  
G0 Z-1  
G1 Z3. F.05  
G28 Z0

waitm (49,1,2,3)  
M99  
M30

waitm (49,1,2,3)  
M99  
M30

EM75:  
M900  
waitm (49,1,2,3)  
T2000  
M99  
M30